

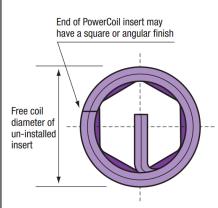
Insert Part Number		3520-18.00X1.0DSL	
Insert Thread Form		Metric Coarse	
Nominal Thread Size		M18 X 2.5	
Insert Length Q (installed)	D	1.0D	
Insert Length Q (installed)	mm	18.000	
Insert Material		304 Stainless Steel	
Insert Coating/Plating		-	
Military Standard	#	MA3329-121	
National Aerospace Standard	#		
Federal Stock	#	-	
National Stock / NATO	#	-	

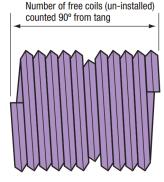
Optimum thread performance with Wire Thread Inserts is achieved when the inserts are installed 1/2 to 1 pitch below the surface of the tapped hole. This means that the actual length of an installed insert is equal to dimension Q less 1/2 to 1 pitch. Dimensions S and T allow for tap end clearance of intermediate taps. When using Bottoming and Spiral Flute Taps these dimensions maybe reduced by an amount equal to 2 thread pitches. Any countersink depths must be added to these dimensions.

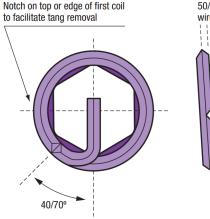
COMPATIBLE POWERCOIL INSTALLATION AND REMOVAL TOOLS				
TOOL TYPE	Part #			
Hand Installation Tool	-			
Tang Break Tool	-			
Removal Tool	3500-RT3			
Machine Installation Tool	-			
Mandrel Installation Tool	-			
Captive Prewinder Tool	3520-18.00HIP			
Non-Captive Prewinder Tool	-			
Spring Loaded tang Break Tool	-			
Pneumatic Front end assembly (FEA)	-			
FEA Mandrel	-			
FEA Nozzle	-			
Pneumatic Tool	-			

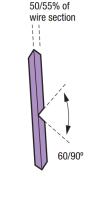
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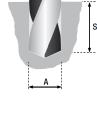


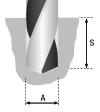


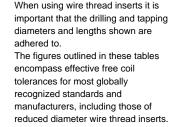




DRILLED HOLE DIMENSIONS INTERMEDIATE/PLUG TAP					
Drill Size	mm	18.80			
Drill Part Number		-			
Drill Size inch	inch	47/64			
Drill Part Number inch		2651-47/64			
A Minor Diameter inimum	mm	18.541			
A Minor Diameter maximum	mm	18.896			
S Drilling Depth minimum	mm	29.25			







IMPORTANT The success of any drilling and tapping operation is dependant upon many factors -type of material being cut, cutting speed,

is not possible to give specific drill

sizes for each material. Drill sizes

coolant, equipment being used - and it

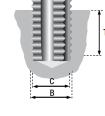
shown are recommendations only and

PowerCoil would strongly suggest that

independent testing be performed for

specific and critical applications.

TAPPED HOLE DIMENSIONS	;		
Tap Size	STI		M18 X 2.50
Tap Size	-		-
B Major Diameter		mm	21.248
C Pitch Diameter MIN		mm	19.624
C Pitch Diameter MAX	5H	mm	19.738
C Pitch Diameter MAX	6H	mm	19.778
T Tapping Depth MIN		mm	26.75
Power Coil Tap Part Number	STI	Taper	3520-18.00T
Power Coil Tap Part Number	STI	Intermediate	3520-18.001
Power Coil Tap Part Number	STI	Bottoming	3520-18.00B
Power Coil Tap Part Number	STI	SpiralPoint	3520-18.00SP
Power Coil Tap Part Number	STI	SpiralFlute	3520-18.00SF



Number of Free Coils – the number of coils on an un-installed insert counted along the insert length 90° from the tang.

